

**LISTING OF CLAIMS**

Claims 1-16 (Cancelled)

17. (Currently Amended) Device for coiling a windable long, metal product, comprising a mandrel having a substantially circular transverse section and rotating around a horizontal, vertical or inclined axis, a containing element to contain said metal product, arranged in correspondence with said mandrel and including at least a lateral wall at least partially extending substantially orthogonal to said axis, and at least a guide and containing device able to be driven between a first working position in which said guide and containing device cooperates with said mandrel, and a second inactive position in which said guide and containing device is arranged distant from said mandrel, wherein said lateral wall of said containing element defines, together with an outer surface of said mandrel, an annular channel which is coaxial with the axis of rotation of said mandrel, and wherein said guide and containing device includes a groove that is able to define an accompanying guide for said metal product along an outer circumference of said mandrel towards said annular channel and coaxial with said annular channel, when said guide and containing device is in said first working position; and  
wherein a flange is applied on said containing element substantially  
perpendicular to said mandrel and shaped so as to have an annular tooth

substantially coaxial with said mandrel, said annular tooth defining said annular channel at a lower part of said containing element.

18. (Previously Presented) Device as in claim 17, wherein said annular channel has a substantially rectangular transverse section.

19. (Previously Presented) Device as in claim 17, wherein said annular channel has a substantially trapezoid section.

20. (Previously Presented) Device as in claim 17, wherein said guide and containing device comprises at least a first flap.

21. (Previously Presented) Device as in claim 20, wherein said guide and containing device comprises a second flap arranged diametrically opposite said first flap.

22. (Previously Presented) Device as in claim 21, wherein said first and second flap constitute, in said first working position, a lateral cover to said annular channel.

23. (Cancelled)

24. (Currently Amended) Device as in claim-~~23~~17, wherein said annular tooth includes an outside surface, wherein said annular tooth is slightly convergent towards the outside surface.
25. (Currently Amended) Device as in claim-~~23~~17, wherein said annular tooth has a thickness substantially equal to the diameter of said metal product, or to a multiple thereof.
26. (Currently Amended) Device as in claim-~~23~~17, wherein the protrusion of said annular tooth is substantially equal to a value of between 1.5 and 2 times the diameter of said metal product.
27. (Currently Amended) Device as in claim-~~23~~17, wherein said flange is interchangeable according to the size of said metal product.
28. (Currently Amended) Device as in claim-~~23~~17, wherein said flange is made of material of great hardness.
29. (Currently Amended) Method for coiling a long metal product, performed by means of a coiling device which includes a mandrel having a substantially circular transverse section and rotating around a horizontal, vertical or inclined axis, a containing element to contain said metal product, arranged at one end of said mandrel and including at least a lateral wall at least partly

extending substantially orthogonal to said axis, and at least one guide and containing device, able to be driven between a first working position in which said guide and containing device cooperates with said mandrel, and a second inactive position in which said guide and containing device is arranged distant from said mandrel, said method comprising the following steps:

- a first step wherein a leading end of said metal product is inserted into a groove of said guide and containing device arranged in said first working position to guide said metal product along an outer circumference of said mandrel;
- a second step wherein said metal product is guided by said groove inside an annular channel defined between said lateral wall of said containing element and an outer surface of said mandrel and coaxially with said axis of rotation of said mandrel;
- a third step wherein an initial segment of said metal product is gripped and clamped in said annular channel by means of friction forces generated between said metal product and the walls of said annular channel;
- a fourth step wherein said metal product is wound onto said mandrel for a pre-determined segment of length;
- a fifth step wherein said guide and containing device is taken from said first working position to said second inactive position; and
- a sixth step wherein said metal product is wound for the remainder of its length; further comprising applying a flange on said containing element substantially perpendicular to said mandrel and shaped so as to have an annular tooth substantially coaxial with said mandrel, said annular tooth defining said annular

channel at a lower part of said containing element..

30. (Previously Presented) Method as in claim 29, wherein during said first step, said metal product is inserted into said groove by means of a distributor of said metal product.

31. (Previously Presented) Method as in claim 30, wherein during said first step, said mandrel is in rotation around its own axis.

32. (Previously Presented) Method as in claim 29, wherein said segment of pre-determined length is between a fraction of one spiral and three spirals.